

Work Order ID 152681***152681***

Page 1

Friday, November 04, 2016 10:13:15 AM

Item ID: D4364-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Run-on Landing Wearplate Fwd

Start Date: 11/4/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/18/2016 Req'd Qty: 2.00

2

Customer:

Reference:

DAS
21
9-89

Approvals: Process Plan:

Date: NOV 04 2016 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4364

C

150

0.00

150

Large Fab

Large Fab

Memo

0.27

***FRONT BENT COULD BE OVER BENT HIGHER ***

1- Weld D4365-041 to wearplate as per dwg D4364

304 S.S. Welding Rod

BATCH #:

134992

2- Transfer drill holes in bar

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Quality Control

Memo

0.00

2 16-11-08 JAL

② 16-11-15 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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152681

Friday, November 04, 2016 10:13:15 AM

Setup Start *NS1*

Stop ***NS2***

Stop ***NS2***

2

2

Run Start *NR1*

Stop *NR2*

Date:

Insp. Stamp

DAS
9
9-89

DAS
41
9-89

10-11-15

DAS
38
9.99

NOV 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID 152681

Friday, November 04, 2016 10:13:15 AM

152681

Page 3

Item ID: D4364-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Run-on Landing Wearplate Fwd

Start Date: 11/4/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/18/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: **FP-002** 0.00***200***

Packaging

Memo

0.00

Packaging

LOCATION : FP002

x2 **d** **ll** **16/11/17**

210

QC21- Final Inspection - Work Order Release 0.00

210

QC

Memo

0.03

Quality Control

DAS
21
9-39

NOV 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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								Completed By	
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Design ☐	☐	Operator ☐		Bending ☐	☐	Set-up ☐	☐
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Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____			
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Picklist Print

Friday, November 04, 2016 10:13:19 AM

Page 1
T

Work Order ID: 152681

152681

Parent Item: D4364-041

D4364-041

Parent Item Name: Run-on Landing Wearplate Fwd

Start Date: 11/4/2016

Required Date: 11/18/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC IPP
REV:B 14.04.22 DWG B DD VERF:JLM IPP REV:C
15.10.16 AS PER DWG REV.C1 DD VERF:JLM IPP REV:D 16.06.17
DWG.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4364-1

Manufactured

No

Each

10.0000

2

D4364-1

Plate

**

16-11-08
js

Location

Loc Qty

Loc Code

WA001

6

136706

6

WA002

4

135612

4

2

D4365-041

Manufactured

No

Each

0.0000

2

D4365-041

Bar Weldment

**

16-11-08
js

152683

2

DQA: _____ Date: _____



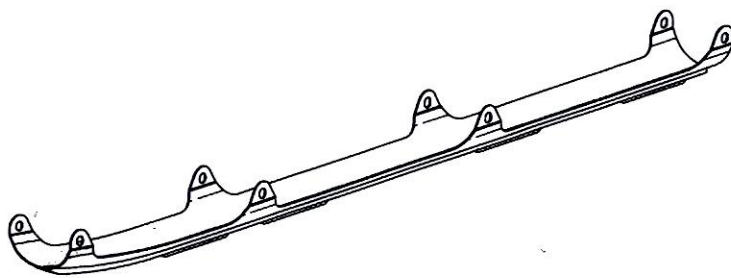
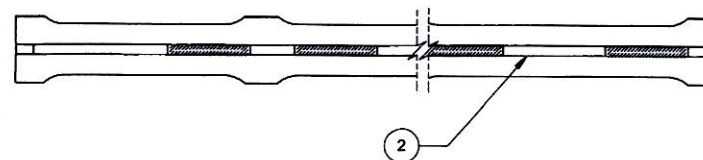
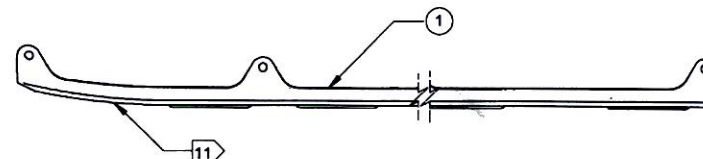
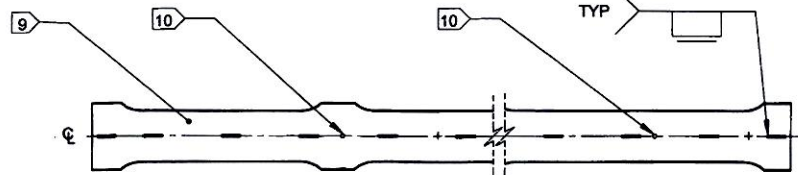
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OTHER :																									

ITEM	QTY	P/N	DESCRIPTION
	X	D4364-041	FWD WEARPLATE ASSY
1	1	D4364-1	PLATE
2	1	D4365-041	BAR WELDMENT



D4364-041 FWD WEARPLATE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-041" PER QSI 044 6.1
- 7) WEIGHT: 4.03 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES THRU D4365-041 BAR WELDMENT FROM D4364-1 WEARPLATE AFTER WELDING
- 11) FORM TO MATCH PROFILE OF D4364-1 AT TIME OF WELDING

RELEASED
2016-06-16
ECN 16-594

APPROVED

C	D4365-041 WAS D4365-1, D4365-043 WAS D4365-3, REMOVE 2059 HARDCOAT WELD (MOVED TO D4365), UPDATE TOLERANCES (SH 3&4), REMOVE VIEWS A-A, B-B (SH 2)	DB	16.01.21
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), CHANGE NOTE 10 (SH 2)	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.01.21	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	